

**Amendments to the Claims:**

The listing of claims will replace all prior versions, and listings, of claims in the application.

**Listing of Claims:**

Claims 1-12 (canceled)

Claim 13 (currently amended) A method of manufacturing a screw tight tube vice frame in a tattoo machine comprising the steps of:

- (a) Drilling an internal taper into a hollow rod and cutting threads onto the exterior surface of said rod;
- (b) Drilling a first hole into a tattoo machine frame but not completely through said frame, such that a portion of said frame remains;
- (c) Drilling a second hole of a smaller diameter than said first hole through the remaining portion of said frame using the same centerline as said first hole, such that there is a transverse hole in said frame;
- (d) Tapping said first hole;
- (e) Screwing said rod into said first hole such that said rod protrudes from said frame;
- (f) Machining a split ring ferrule with tapered ends of an angle equivalent to said internal taper of said rod;
- (g) Machining a nut adapted to screw onto said rod with said ferrule between said rod and said nut such that said ferrule ~~may be~~ is compressed by said nut to retain objects disposed within said ferrule.

Claims 14-35 (canceled)

Claim 36 (new) A method of manufacturing a screw tight tube vice frame in a tattoo machine comprising the steps of:

- (a) Drilling an internal taper into a hollow rod and cutting threads onto the exterior surface of said rod;
- (b) Drilling a first hole into a tattoo machine frame but not completely through said frame, such that a portion of said frame remains;

- (c) Drilling a second hole of a smaller diameter than said first hole through the remaining portion of said frame using the same centerline as said first hole, such that there is a transverse hole in said frame;
- (d) Tapping said first hole;
- (e) Screwing said rod into said first hole such that said rod protrudes from said frame;
- (f) Machining a split ring ferrule with tapered ends of an angle equivalent to said internal taper of said rod;
- (g) Machining a nut adapted to screw onto said rod with said ferrule between said rod and said nut such that said ferrule ~~may be~~ is not compressed by said nut to retain objects disposed within said ferrule.